

27

SPUT

DART AEROSPACE LTD	Work Order:	21098 A
Description: Lug Assembly 206L/407 GHW Lug	Part Number:	D2659
Dwg: D2659 Rev. A; D2658 Rev. D; D2657 Rev. A	Qty:	60
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HJ	04.06.11	60
2	PG	Issue P/O: <u>7006527</u> Laser cut per Drawing Flat pattern D2658 Material release note required	W	04.06.14	60
3	RG	Receive and inspect for transit damage Ensure the material release note attached	WCL	04/06/23	66
4	QC6	Inspect dimensions per template D2658T1	AB	04.06.23	66
5	GA	Deburr as required.	SB	04/06/07	66
6	GB	Bend on CNC brake using DT8254 Identify as D2658	SB	04/07/07	66
7	QC5	Inspect work to Step 6	AB	04.08.04	66
8	MV	Cut blanks: 2.200" long Material: ASTM A36 steel bar 2.50" x 0.75" thick (M1010-B0.750 x 02.500) Batch <u>M15138</u>	ML	04/08/04	60
9	MV	Machine per folio FA040 and Dwg D2657	ML	04/08/05	60
10	QC2	Inspect parts as they come off the CNC machine. Identify as D2657	ML	04/08/05	60
11	QC8	Second inspection	ML	04/08/05	30
12	WS	Weld as per Dwg D2659 using location Jig DT8484 Qty Description Batch A/R Steel Rod <u>M11678</u>	ML	04/08/05	30
13	MV	Tumble & Deburr	SB	04/08/06	30
14	QC9 & 5	Inspect weld and work to Step 13	AB	04.08.06	30
15	FP	Powder Coat White (Ref 4.3.5.2) per QSI 005 4.3	ML	04.08.09	30
16	QC3	Inspect Powder Coat	ML	04.08.10	30
17	ST	Identify and Stock	CL	04/08/10	30
18	AC	Cost / part <u>11.96</u>	545	04-08-18	30
19	DC	Close W/O <u>12.28</u> Inspect Level 21	HJ	04.08.19	30
20					

Rev	Date	Change	Revised By	Approved
A		New Issue	BW	
B	98.09.10	Inspection levels re format	CS	
C	02.06.14	Combined D2658 flat & D2658 bent into D2659	NG	
D	02.09.20	Re-format; Incorporated D2657; D2658	KJ RF	

RELEASED
02/10/02 RF

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

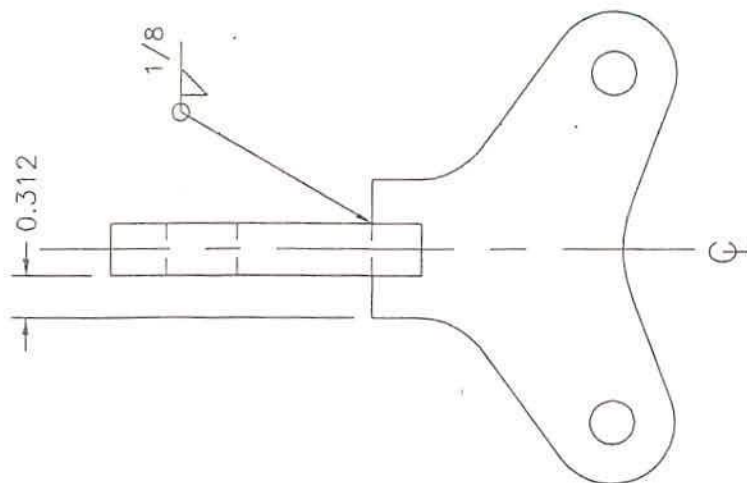
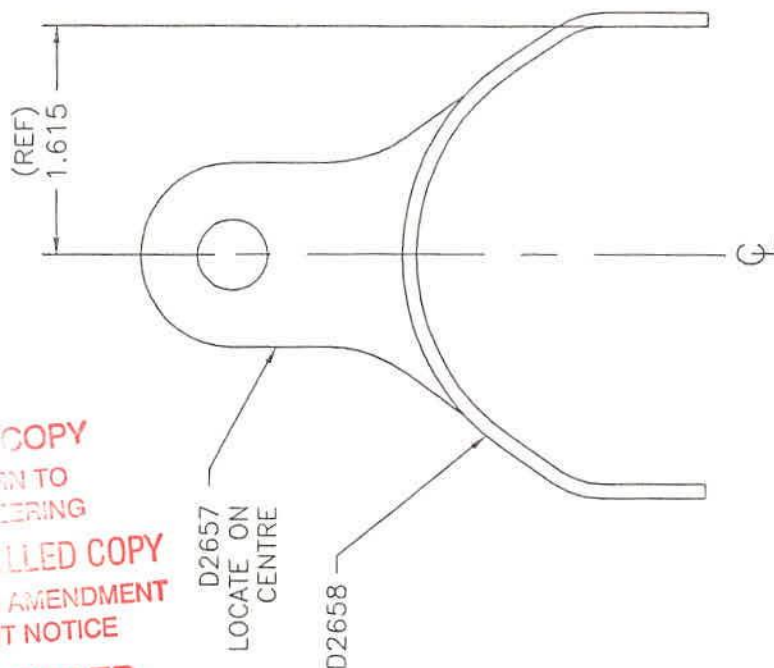


DESIGN <i>ms</i>	DRAWN BY <i>ms</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ms</i>	APPROVED <i>ms</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 PS

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WITHOUT NOTICE

WORK ORDER
NO. 21098



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 11, 2004
11:26 am

Work Order No : 0021098
Project Name : D2659
Project For : WK427
Work Order Type : Main
Main WO Number :
House Part Number : D2659
Description : Lug Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 06-11-04
Est Finish Date : 06-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

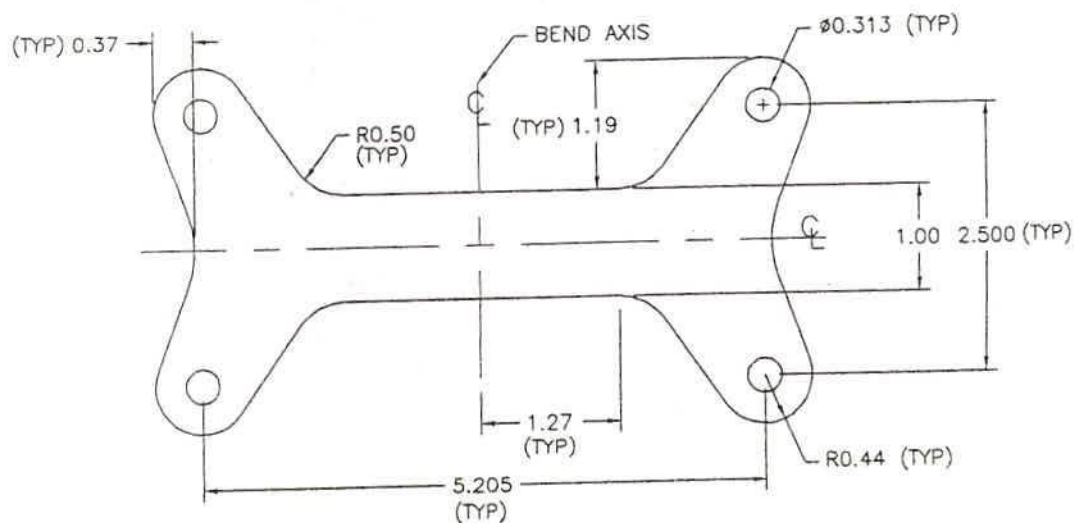
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

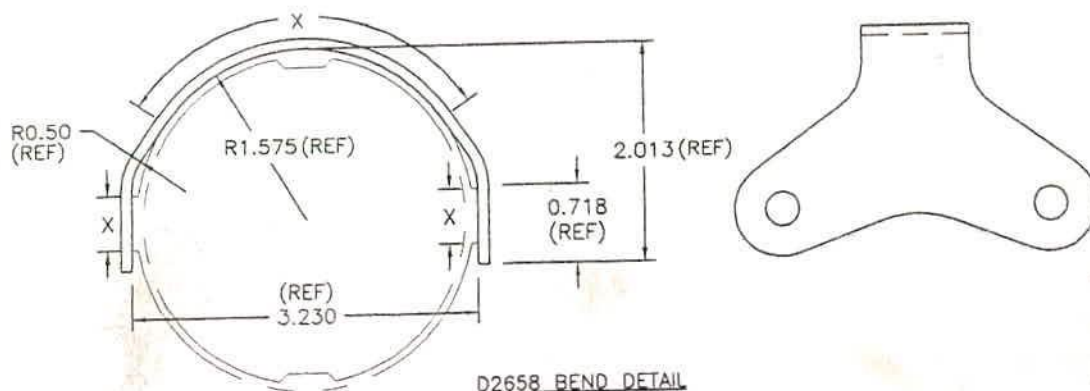


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. SHEET 1 OF 5
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

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GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



California Steel Industries
14000 San Bernardino Ave.
Fontana, California 92335
Ph (909) 350-6300


CERTIFIED TEST REPORT

CUSTOMER ORDER P30307ME003	NO. NUMBER 02-2962-01	SHIPPING DATE 05/22/03	CAR NUMBER RR: BNSF534686	TALLY NUMBER PO 250279105 1/
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B I L L O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR. VANCOUVER BC, CANADA, V5X2V3	S H I P T O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., IN 888 S.E. MARINE DR. VANCOUVER BC V5X 2
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MARK ALL DOCUMENTS W/P.O. P30307ME003 FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX
#604-301-3244.

END USE	WAREHOUSE STOCK
PROD	H.R. COILS - P & O - PRIME
SPEC	CQ-ASTM-A-569-96

T/R 1	INSPECTION MILL			
DESCRIPTION	COILS, PIECES OR BUNDLES	HEAT NUMBER		
.1040 x 48.0000 x COIL NOM ME 12 GA	4 2	M64660 M64734		
I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.  CHIEF - LABORATORY SERVICES				

MECHANICAL PROPERTIES										CHEMICAL ANALYSIS										03:49:17 05/22/03	
HEAT OR LOT NUMBER	SLAB NUMBER	LO CO	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION F	% ELONGATION T	BEND TEST	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Co	Ti	N
M64660								07	.24	.007	.005	.014	.01	.00	.00	.00	.046	.001	.002	.000	.003
M64734								06	.25	.009	.007	.013	.01	.01	.00	.00	.047	.001	.002	.000	.004

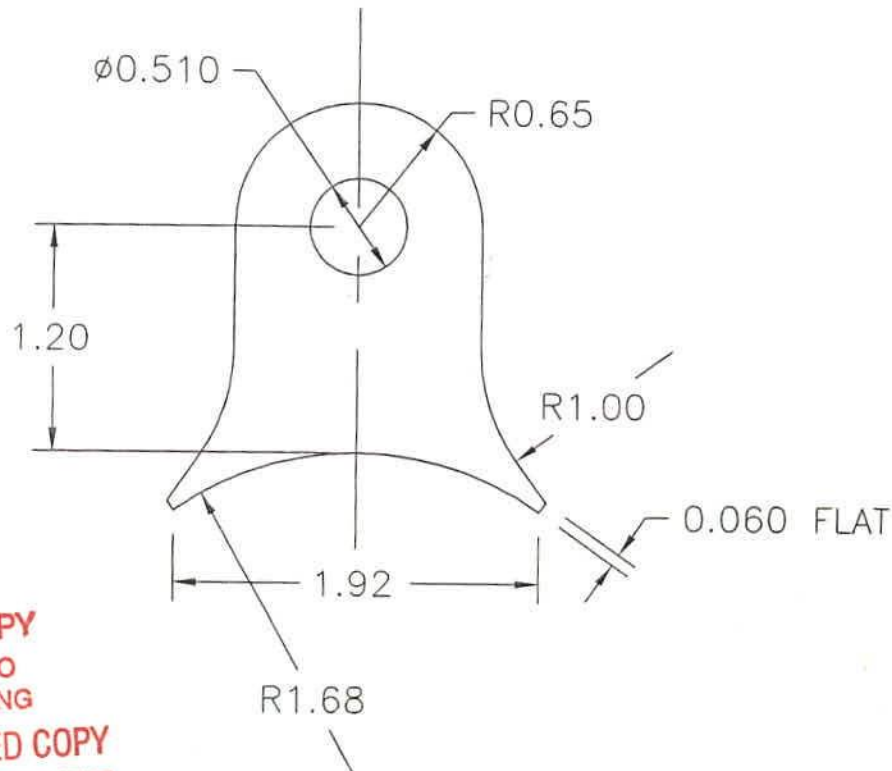
CTR-001 PTLU022L 890712

12 ga P+O



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2657	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG	SCALE 1:1
A	97.11.03	NEW ISSUE	

RELEASED
97/11/07 DS



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NO. 21098

0.063
#00.04.05
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BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.375 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE

